Date:

Monday, 09/03/2009 1:42:04 PM

Julie Dawson User:

## **Process Sheet**

Customer Job Number

First Issue

Comment

**Previous Run** 

: CU-DAR001 Dart Helicopters Services

: 46328

**Estimate Number** P.O. Number

: 10313

: 09/03/2009 This Issue Prsht Rev.

: NC

: //

: 45316

Type

S.O. No. :

**Part Number** 

**Drawing Name** 

: D26483

: D

**Drawing Number** 

: N/A

: WEARPAD

: D2648 REV D

**Project Number** 

**Drawing Revision** 

Material

: 27/03/2009 **Due Date** 

Qty:

20 Um:

Each

Written By Checked & Approved By

: SMALL /MED FAB

: Est: E 02.09.18

Re-format; Incorporated D2648-1 KJ/RF

Est Rev:F

Now on Waterjet 06-08-14

Total:

JLM

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M1010S16GA

1010/1025 sheet 16GA



Comment: Qtv.:

0.1134 sf(s)/Unit

2.2680 sf(s)

1010/1025/A21/6aA SHEET

(M1010S16GA)

105706 Batch:

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2648

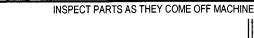
Dwg Rev: 1 Prog Rev:\_

IB 9-3-12



2-Deburr if necessary

QC2





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

3.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary



Page 1

Form: rprocess

<b>Dart Aerospa</b>	ce	Ltc	ı
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W/O:			W	ORK ORDER CHANG	iES					
DATE	STEP	PRO	OCEDURE CH	ANGE	ı	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No		DAR #-	Fault Cate		NCD.	Voc. N	o DOA:	Dete		
1 411 140						R: Yes No DQA: Date: : N/C Closed: Date:				
NCR:				ER NON-CONFORM						
DATE	STEP	Description of NC	Description of NC Corrective Action			Ciam 0	Verification		Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspector	
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NOTE: Date & initial all entries

Date: Monday, 09/03/2009 1:42:04 PM Julie Dawson User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: WEARPAD Job Number: 46328 Part Number: D26483 Job Number: Seq. #: Description: **Machine Or Operation:** BRAKE NC NC BRAKE 6.0 Comment: NC BRAKE 1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326. SB 09/03/ 2-Identify as D2648-3 LARGE FAB 1 LARGE FABRICATION RESOURCE 1 7.0 Comment: LARGE FABRICATION RESOURCE 1 Qty Description M109813 A/R560Hardcoat 1-Weld as per Dwg D2648 using Jig DT 8210 2-Remove any weld that penetrated through Wearpadif necessary 8.0 QC10 VISUAL INSPECTION OF GROUND WELDS Comment: VISUAL INSPECTION OF GROUND WELDS INSPECT WORK TO CURRENT STEP 9.0 QC5 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING 10.0 POWDER COATING Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 START TIME: **OVEN TEMPERATURE:** FINISH TIME: 11.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 12.0 Comment: PACKAGING RE Location:

	Dart	<b>Aeros</b>	pace	Ltd
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W/O:			W	ORK ORDER CHANG	ES	<del></del>					
DATE S	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
						- 1					
					1						
Part No: _		PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	Date:			
		Resolution: QA: N/C Closed:									
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	R)		·			
DATE S	STEP	Description of NC	Description of NC Corrective Action			Section B Verifi			Approval		
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Approval Chief Eng	QC Inspector		
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NOTE: Date & initial all entries

Date:

Monday, 09/03/2009 1:42:04 PM

User:

Julie Dawson

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

**Drawing Name: WEARPAD** 

Job Number: 46328

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/30

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Da	rt	Ae	ros	pa	се	Ltd
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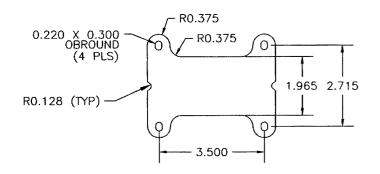
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Part No	·	PAR #: Fault Category: NCR: Yes					No <b>DQA</b> : <b>Date</b> :					
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NCR:		,	WORK ORDE	ER NON-CONFORM	IANCE	(NCR)						
DATE	STEP	Description of NC	Description of NC Corrective Action			Veriticat			Approval	Approval		
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspecto		
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NOTE: Date & initial all entries

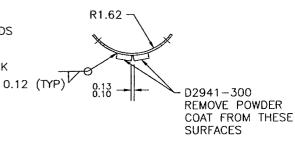
DART AEROSPACE LTD	Work Order: んしろ	28	
Description: Wearpad	Part Number: D26	48-3	
Inspection Dwg: D2648 Rev: D	Page	1 of 1	

ilispection Dwg	. D2040 <b>Rev.</b> D			l		rage	1011
	FIRST A	ARTICLE IN	SPECTIO	ON CHE	CKLIST		
	X	First Articl	е	Protot	ype		
Drawing	Talamana	Actual		Daire	Method of	0	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Cor	nments
1.965	+/-0.010	1.962	8				
2.715	+/-0.010	2715	k				
3.500	+/-0.010	3.501	Xe	}			
0.220 x 0.300	+/-0.010 x +/-0.010	x307	×				16
R0.375	+/-0.010	275,	æ				
R0.128	+/-0.010	1198	علا				
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Measured by:	(13)	Audited by:	11		Prototype	Approval:	N/A
Date:	9-3-12	Date:	1510	3-12		Date:	N/A
Rev Date	Change				D	avisad by	Approved
A 06.10.16					K	evised by J/JLM	Approved

## D2648-1 FLAT PATTERN

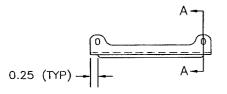


R1.62 7560 HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.063 TO 0.125 THICK 0.50

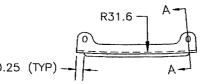


SECTION B-B

## D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)

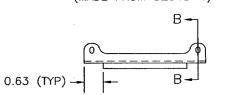


D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



SECTION A-A

## D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)







D	99.11.17	ADDED D2648-7
С	97.06.26	R31.6 WAS R19.6
В	97.05.30	ENLARGE OBROUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. REV. D
Ht.	H	D2648 SHEET 1 OF 1
DATE		TITLE SCALE
99.11.17		WEARPAD 1:2

BREAK ALL SHARP CORNERS 0.063 MAX

MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)

FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALE DIMENSIONS ARE IN INCHES

UNCONTROLLE